

Work Order ID 133293

133293

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June-01-15 1:49:11 PM

Item ID: MISC - Testing

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Eng Testing

Start Date: 6/01/15 Start Qty: 1.00

Cust Item ID:

Required Date: 6/05/15 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00

100

Crosstubes

Crosstubes

Memo

1. PICK D6021
2. MACHINE TO 2.3" OD
3. GRIND SURFACE SMOOTH USING GR80 DRUM BELT AND FINISH WITH A COARSE BLENDXTM DRUM (WALTER SURFACE TECHNOLOGIES). CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
4. DEGREASE USING 4105S WASH 'N WIPE. USE CLEAN LINT FREE CLOTH. RINSE ANY RESIDUE THOROUGHLY, WIPE/DRY WITH CLEAN DRY CLOTH TO ENSURE SURFACE CONTAMINANTS REMOVED.
5. KEEP ALL SURFACES CLEAN UNTIL PRIMED. USE CLEAN GLOVES TO HANDLE. SURFACES SHALL BE KEPT FREE FROM DIRT, DUST, FINGER MARKS, AND OTHER CONTAMINANTS.

Qty (3)

6" long pieces

3 8 J.C.-L. 5/06/08

110

0.00

110

Powdercoat

Powder Coating

Memo

6. POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
7. CUT INTO (3) 6" LONG SECTIONS

START: 8:40
OVEN. T: 400°
FINISH: 9:10

3 15-6-15 04388

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Item ID: MISC - Testing Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eng Testing
 Start Date: 6/01/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/05/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00				3	φ		DAS 12 9-89 15/6/16
120									
Eng	Memo	0.00							
Engineering	ENGINEERING APPROVAL								
130		0.00				3	φ		DAS 12 9-89 15/6/22
130									
Purchasing	Memo	0.00							
Purchasing	SEND TO EXOVA FOR GRAVEL TESTING PO <u>28902</u>								

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Item ID: MISC - Testing Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Eng Testing
 Start Date: 6/01/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/05/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

RD 15.74801

20150917
SH

Linda Lacelle

From: Chris Provencal
Sent: June-01-15 1:26 PM
To: Linda Lacelle
Cc: William Monterroza; Nigel Forbes
Subject: Need Gravel Test Samples

Linda,

Can we have 4 w/o's to create the following. This is for gravel testing at Exova:

W/O #1, Existing process (control)

Cut qty(3) 6" long sections from painted 350 tube. This tube is already painted, so it just needs to be picked. We'll pick the fill in the p/n & b/n of the picked tube.

W/O #2, Stainless w/ Metalok

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Axalta 13205S Aluminum Cleaner per manufacturer's instructions
7. Apply Axalta Metalok 230S Adhesion Promoter per manufacturer's instructions
8. Prime and paint outside of tube per Dart QSI 005 4.2
9. Cut into (3) 6" long sections

W/O #3, Stainless w/ Military wash primer

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.

5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Apply Sherwin Williams DOD-P-15328D per manufacturer's instructions.
7. Prime and paint outside of tube per Dart QSI 005 4.2
8. Cut into (3) 6" long sections

W/O #4, Stainless w/ powder coat

1. Pick D6021
2. Machine to 2.3" OD
3. Grind surface smooth using GR80 drum belt and finish with a coarse Blendex™ drum (Walter Surface Technologies). Circumferential grind marks are unacceptable.
4. Degrease using 4105S Wash 'n Wipe. Use clean lint free cloth. Rinse any residue thoroughly, Wipe/dry with clean dry cloth to ensure surface contaminants removed.
5. Keep all surfaces clean until primed. Use clean gloves to handle. Surfaces shall be kept free from dirt, dust, finger marks, and other contaminants.
6. Powder coat white (4.3.5.2) per Dart QSI 005 4.3
7. Cut into (3) 6" long sections

The D6021 material should be able to be cut from the excess mat'l on the ends of the raw extrusion. I believe there's at least 12" extra material on each tube.

Thanks,
Chris